

GILKIN

Dart Aerospace Ltd.

Date: Wednesday, 10/25/2006 11:14:44 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001	Drawing Name	: PLUG
Job Number	: 29165		
Estimate Number	: 10178		
P.O. Number	: N/A	Part Number	: D25941
This Issue	: 10/25/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2594 REV B1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28452	Drawing Revision	: B1
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 11/15/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	64
Comment	: Est D 02.08.22 Make in Cobra KJ	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 REMOVE FROM STOCK
 D2594-1 B 2636 4
 STRIP WHITE PAINT

FL 06/11/14 (71)

2.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat GREEN (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

FL

06/11/14 X 71

3.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m.

06/11/14

(71)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: FP

a.m.

06/11/14

(71)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/11/15

Job Completion



U 06/11/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DD* Date: 06/06/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

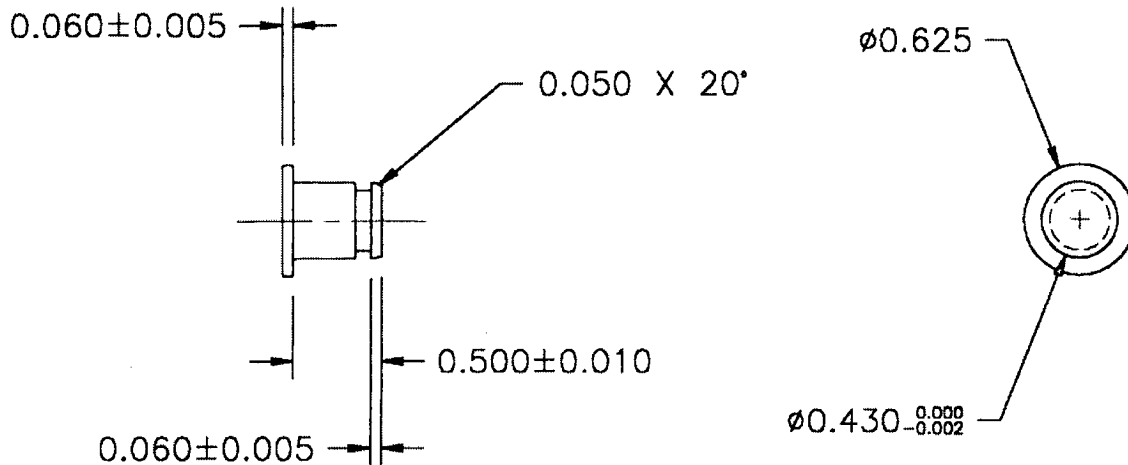
NOTE: Date & initial all entries



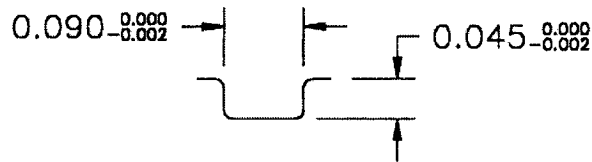
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD POWDER COAT, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSE 005 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 3 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29165